

Work Order ID 65092

Thursday, January 06, 2011 10:40:59 AM



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly

Stop



Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

A

100

0.00



Large Fab

Memo

0.00

11-2-9 *(26)*

Large Fab

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH#: *M116747*

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: *M107051*

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

lpl 11.02.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 1/6/2011 Start Qty: 6.00



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Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.60

8 11/02/10

(46)

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 11/5/28

Memo

0.00

Powder Coating

START TIME: 10:30
OVEN TEMPERATURE: 320°
FINISH TIME: 11:00

6 BL 11-2-11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 φ M 11/02/14

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Work Order ID 65092

Thursday, January 06, 2011 10:40:59 AM



Page 4

Item ID:	D4154-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearplate Assembly			Stop		
Start Date:	1/6/2011	Start Qty:	6.00			
Required Date:	1/13/2011	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

OK 11/02/11

UNF
11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 10:41:04 AM

Page 1

Work Order ID: 65092

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 1/6/2011


Required Date: 1/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
10.11.04 added DT9684 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1  Plate		Manufactured	No			100	Each	4.0000	1	6		11-1-31	

65079 x 6

Location

Loc Qty

Loc Code

WA

4

62708

4

D4155-1

Manufactured No

100

Each

7.0000

1

6

Bar

Location

Loc Qty

Loc Code

ST

2

WA

5

62709

5

65080 x 5

W/O:		WORK ORDER CHANGES					
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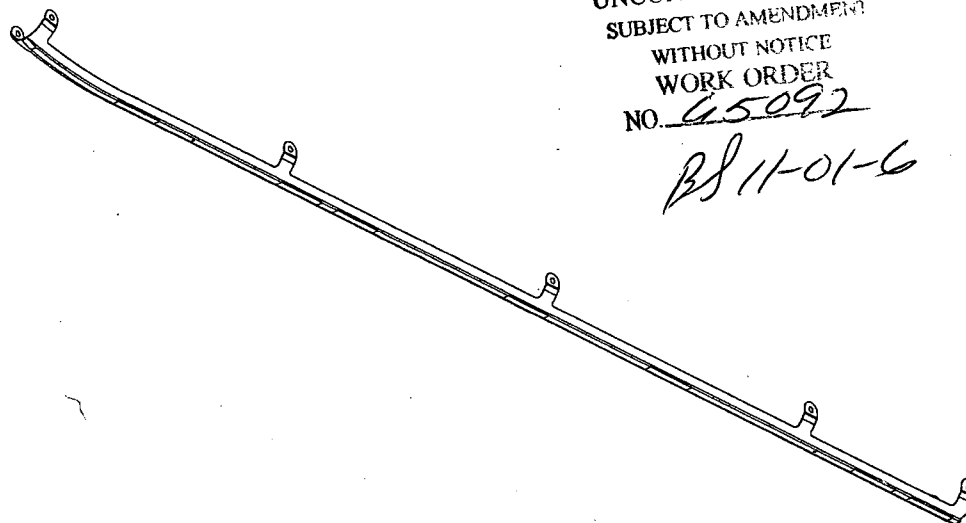
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45092

BS 11-01-6



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15
MD

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

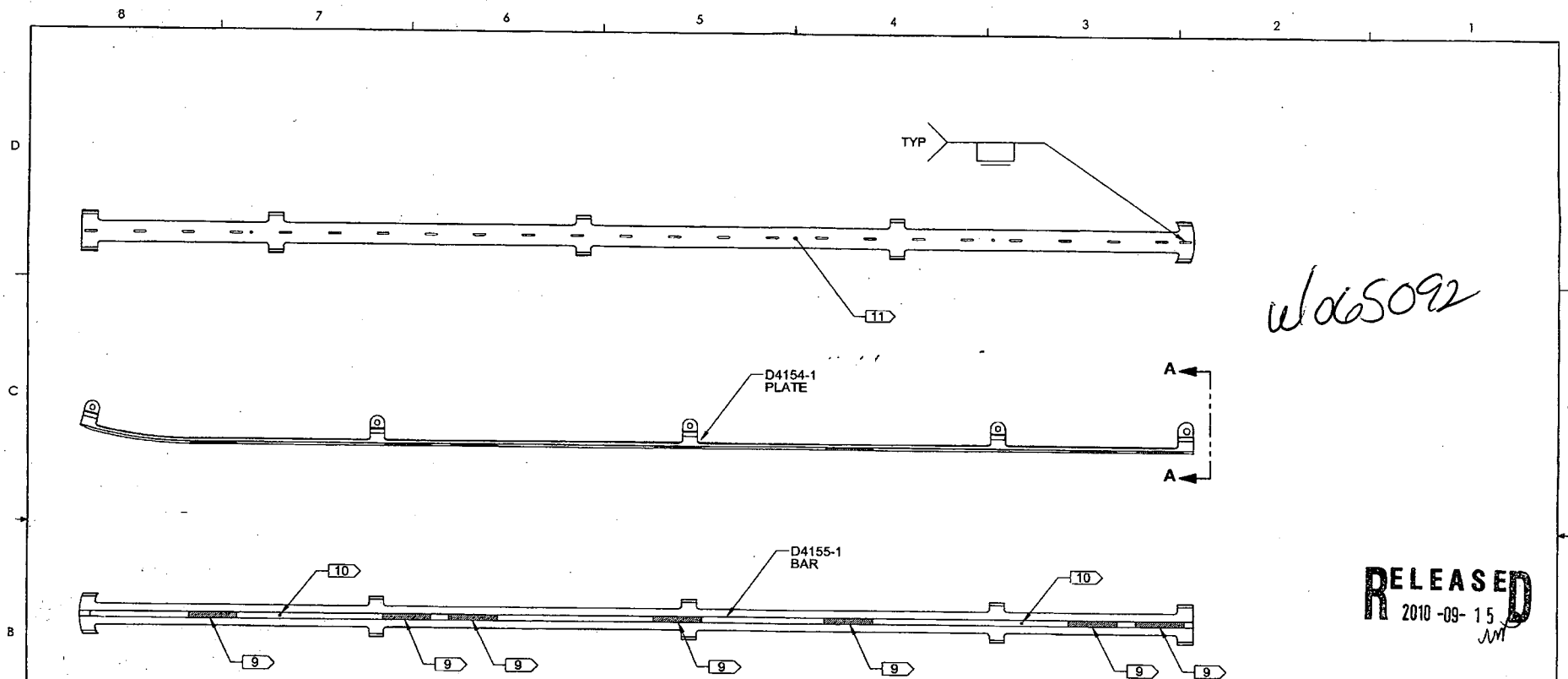
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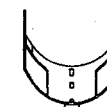
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D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15
AM



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	B	D4154	SHEET 2 OF 3
APPROVED	AM	TITLE	SCALE
DATE	10.07.22	WEARPLATE ASSEMBLY	NTS

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for Pur 1 Rockwell
4715
110215,

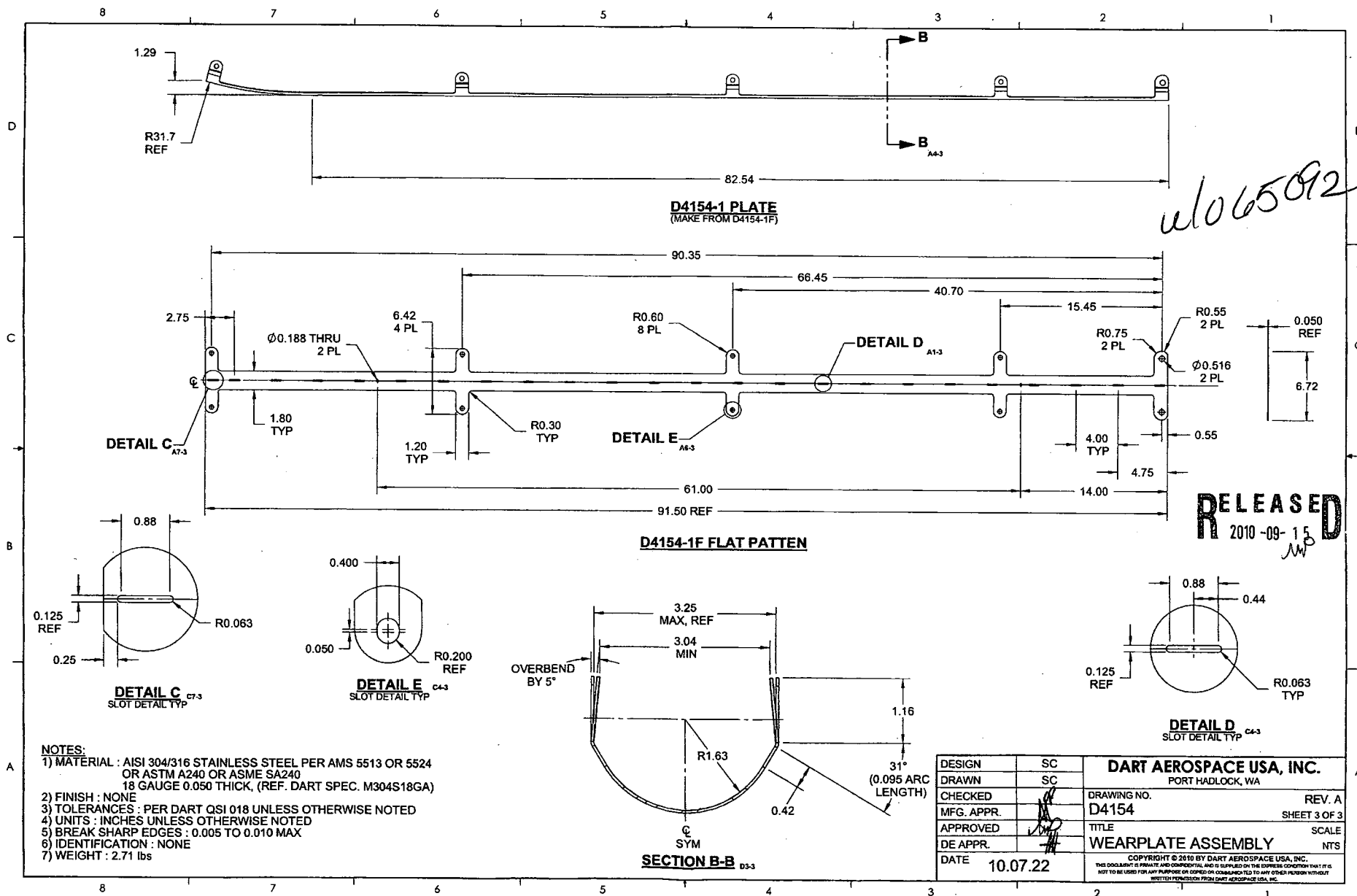
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